



NOTES:

1. THIS IS A ULTRA-HIGH WELDMENT ASSEMBLY (UHV)

2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:

A) CIMCOOL 5 STAR 49

B) TRIM SOL

3. WELDMENT ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10<sup>-10</sup> STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:ALCATEL ASM-110TCL  
VARIAN NCR 925 OR 936  
VEECO MS-9, MS-90 OR MS-18  
Du PONT CEC 24-120B

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. DIMENSIONS IN [ ] ARE MILLIMETERS

5. CERTIFICATION OF ULTRASONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE TO SIGN SUCH CERTIFICATIONS.

ITEM	CHANGE DESCRIPTION	BY	CHKD	DATE
1	Ø6.010 WAS 6.020	RAF	J.C.	7/6/93
1	ADDED	RAF	J.C.	7/6/93
REVISIONS				

2	FLANGE CONNECTING TUBE	SST 304	1	
1	BLOCK CONNECTING TUBE	O.F.H.C.	1	
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES				
A12197				
THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY				
ADVANCED PHOTON SOURCE				
M3 BM FRONT END				
SECOND FIXED MASK				
EXPLOSIVE BONDING TUBE				
SCALE: 1:1				
SHEET 1 of 1				
DRAWING NUMBER: P4102020101-220102-01				

DESIGNED BY	R. KRAKORA	DATE	3/93
CHECKED BY	J. CHANG	DATE	6/25/93
DESIGNED BY	R. KRAKORA	DATE	3/93
CHECKED BY	J. CHANG	DATE	6/25/93
APPROVED/RELEASED			
MATERIAL			

REVISIONS	DATE	BY	CHKD	DATE
1	7/6/93	RAF	J.C.	7/6/93
2	7/6/93	RAF	J.C.	7/6/93